

002211



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-588-041**Job Sheet 175324****Part No:** D350-588-041**Job Qty:** 1 ea**Part Name:** Aft Door Assembly**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 4/3/18**Job Tracking No:****Due Date:** 4/20/18**Created By:** Chantal Lavoie**Type:** Stock**Description:**

Note: DWG DSI9690 REV A , DSI9760-011 REV A , D2445/D350-588 REV D/D IPP P 04.02.04 Reformat KJ/DS IPP
Rev:Q as per DSI9414 DD verified by:EC IPP Rev:R add pick kit DD 10.03.29 verified by:EC IPP REV:S
14.04.28 AS PER DSI9690 DD VERF:JLM

Ship Via:DAS
10
9-89 C H 003DAS
21
9-89**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	1 pcs		4/19/18	0.00	0.00	Purchasing	39489	CD 18/04/03
120	Packaging	1 pcs		4/19/18	0.00	0.00	Packaging2		AT 18/04/03
130	QC	1 pcs		4/19/18	0.00	0.00	QC6		PD 18.4.3.
140	Small Fab	1 pcs		4/20/18	0.00	1.96	Small Fab-4		FF
150	QC	1 pcs		4/20/18	0.00	0.00	QC5		PD 18.4.4
155	Packaging	1 pcs		4/20/18	0.00	0.00	Packaging1-3		APR 04 2018
160	QC	1 pcs		4/20/18	0.00	0.00	QC4		
165	DC	1 pcs		4/20/18	0.00	0.00	DC		
170	Packaging	1 pcs		4/20/18	0.00	0.00	Packaging3-1		Smb
180	QC21-FG	1 Ea		4/20/18	0.00	0.00	QC21		fg 022

DAS
21
9-89

APR 05 2018

PN : D2445 Rev D
Att Baggage Door
SN: DAE007-029
Lot# : 2017-12-07

31



Aft Door Assembly

PART NO: D350-588-041
Serial No/Batch: S057686
Revision:
Operation:
Change No:

Packaging
CHG003

Mfg Date: 04/03/18
Job No: 175324

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2445P	Aft Door Assembly	1 pcs (1 ea)	110-Purchasing	5057675
AN526C832R9	Screw	8 Ea (8 ea)	140-Small Fab	5058035
D2143	Hinge Bracket	1 Ea (1 ea)	140-Small Fab	5058049
D2144	Hinge Doubler	1 Ea (1 ea)	140-Small Fab	5058050
D2463	1/2" Seal (\$ Per Foot)	7.2500 ft (7.25 ea)	140-Small Fab	5021111
D2585	Latch Clamp	2 Ea (2 ea)	140-Small Fab	5038640
D2586	Door Latch	2 Ea (2 ea)	140-Small Fab	5058060
D2621	Latch Plate	2 Ea (2 ea)	140-Small Fab	5058062
D2857-1	Hinge Bracket	1 Ea (1 ea)	140-Small Fab	5058064
D2857-2	Hinge Bracket	1 Ea (1 ea)	140-Small Fab	5058065
MS21042L08	Nut	8 Ea (8 ea)	140-Small Fab	5058038
MS21042L3	Nut	2 Ea (2 ea)	140-Small Fab	5058040
MS27039-1-15	Screw	2 Ea (2 ea)	140-Small Fab	5058043
NAS1149D0363J	Washer	2 Ea (2 ea)	140-Small Fab	5058044/5058045
NAS1149DN832J	Washer	8 Ea (8 ea)	140-Small Fab	5058046/5058047
AN526C1032R7	Screw	2 Ea (2 ea)	155-Packaging	5058033
AN526C832R8	Screw	8 Ea (8 ea)	155-Packaging	5058034
D2150	Packer Doubler, Hinge	2 Ea (2 ea)	155-Packaging	5058051
D2151	Packer Doubler	2 Ea (2 ea)	155-Packaging	5058052
D2153	Door Prop	1 Ea (1 ea)	155-Packaging	5058053
D2154	Bracket, Stud	1 Ea (1 ea)	155-Packaging	5058054
D2237	Striker Plate	2 Ea (2 ea)	155-Packaging	5058055
D2461	Neoprene D Seal (\$Per Foot)	7.2500 ft (7.25 ea)	155-Packaging	5058057
D2589	Keys, Key Chain	1 Ea (1 ea)	155-Packaging	5058061
D2690-17	Cable	1 Ea (1 ea)	155-Packaging	5058063
D2858-1	Hinge Bracket	1 Ea (1 ea)	155-Packaging	5058066
D2858-2	Hinge Bracket	1 Ea (1 ea)	155-Packaging	5058067
D5080-041	Striker Plate Assembly	2 Ea (2 ea)	155-Packaging	5058068
FG-778150-550-ROL	7781 9 oz Glass 50" x 125 yd	1 sf (1 ea)	155-Packaging	5058048
MS20426AD3-4	Rivet	12 Ea (12 ea)	155-Packaging	5058036
MS20470AD4-5	Rivet, Universal Head	18 Ea (18 ea)	155-Packaging	5058037
MS21042L08	Nut	10 Ea (10 ea)	155-Packaging	5058039
MS21042L3	Nut	4 Ea (4 ea)	155-Packaging	5058040/5058041
MS27039-08-11	Screw	2 Ea (2 ea)	155-Packaging	5058042
NAS1149D0363J	Washer	2 Ea (2 ea)	155-Packaging	5058044
NAS1149DN832J	Washer	16 Ea (16 ea)	155-Packaging	5058047

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2445P	1	6	0
140-Small Fab	AN526C832R9	8	329	0
	D2143	1	17	0
	D2144	1	18	0
	D2463	7	442	0
	D2585	2	62	0
	D2586	2	18	0
	D2621	2	47	0
	D2857-1	1	26	0
	D2857-2	1	21	0
	MS21042L08	8	2,913	0
	MS21042L3	2	2,734	0
	MS27039-1-15	2	398	0
	NAS1149D0363J	2	2,966	0
	NAS1149DN832J	8	2,364	0
155-Packaging	AN526C1032R7	2	64	0
	AN526C832R8	8	256	0
	D2150	2	31	0
	D2151	2	26	0
	D2153	1	4	0
	D2154	1	20	0
	D2237	2	46	0
	D2461	7	600	0
	D2589	1	245	0
	D2690-17	1	24	0
	D2858-1	1	21	0
	D2858-2	1	9	0
	D5080-041	2	14	0
	FG-778150-550-ROL	1	420	0
	MS20426AD3-4	12	3,904	0
	MS20470AD4-5	18	3,638	0
	MS21042L08	10	2,913	0
	MS21042L3	4	2,734	0
	MS27039-08-11	2	1,493	0
	NAS1149D0363J	2	2,966	0
	NAS1149DN832J	16	2,364	0

Part Specifications

Specifications could not be found.

Plex 4/3/18 7:57 AM dart.lavoie.chantal



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039489

Supplier: FDC001-VC
FDC Composites Inc.
45 chemin de L'Aéroport, Local 26
St-Jean-sur-Richelie
QC
J3B 7B5 Canada
Phone: 450-357-1344 ext1303
Fax: 450-357-1194

PO No: PO039489
PO Date: 4/3/18
Due Date: 4/3/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D2445P			Aft Door Assembly	Firmed	4/3/18	1 pcs	0 pcs	1 pcs	\$240.00/pcs	\$240.00
Line Item Note job no. 175320											
2	D2445P			Aft Door Assembly	Firmed	4/3/18	1 pcs	0 pcs	1 pcs	\$240.00/pcs	\$240.00
Line Item Note job no. 175321											
3	D2445P			Aft Door Assembly	Firmed	4/3/18	1 pcs	0 pcs	1 pcs	\$240.00/pcs	\$240.00
Line Item Note job no. 175322											
4	D2445P			Aft Door Assembly	Firmed	4/3/18	1 pcs	0 pcs	1 pcs	\$240.00/pcs	\$240.00
Line Item Note job no. 175323											
5	D2445P			Aft Door Assembly	Firmed	4/3/18	1 pcs	0 pcs	1 pcs	\$240.00/pcs	\$240.00
Line Item Note job no. 175324											

Grand Total: \$1,200.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 4/3/18 8:39 AM dart.lavoie.chantal



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35626**

Purchase Order Date 3/17/2017

PO Print Date 4/3/2018

Page Number 1 of 3

Order From :

VC-FDC01

Ship To : DART AEROSPACE LTD

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REFERENCE ONLY

Contact Name

Vendor Phone

450-357-1344 ext303

Ship To Contact

Ship To Phone

Ship Via:

FedEx Economy collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	152133	D2445 DOOR RE-WORK	8/31/2017 Yes 8/31/2017		0.00	\$240.00	\$0.00
Line Total:							\$0.00
2	152134	D2445 DOOR RE-WORK	8/31/2017 Yes 8/31/2017		0.00	\$240.00	\$0.00
Line Total:							\$0.00
3	152136	D2445 DOOR RE-WORK	8/31/2017 Yes 8/31/2017		0.00	\$240.00	\$0.00

Note:

4/3/2018



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35626**

Purchase Order Date 3/17/2017

PO Print Date 4/3/2018

Page Number 2 of 3

Order From :

VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450-357-1344 ext303

Ship To Contact

Ship To Phone

Ship Via:

FedEx Economy collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: \$0.00

4	152138	D2445 DOOR RE-WORK	8/31/2017	0.00	\$240.00	\$0.00
			Yes			
			8/31/2017			

Line Total: \$0.00

5	153342	D2445 DOOR RE-WORK	8/31/2017	0.00	\$240.00	\$0.00
			Yes			
			8/31/2017			

Line Total: \$0.00

Note:

4/3/2018



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35626**

Purchase Order Date 3/17/2017

PO Print Date 4/3/2018

Page Number 3 of 3

Order From :

VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-357-1344 ext303

Ship To Contact

Ship To Phone

Ship Via: FedEx Economy collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

6	71401-45	PROCUREMENT QUALITY CLAUSES	8/31/2017	1.00	\$0.00	\$0.00
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No

Procurement Quality Clauses

8/31/2017

A004 faa-pma/tso

A005 right of entry

A007 first article inspection (FAI) by seller, (documentation maintained by supplier)

A012 chemical and physical test report

A016 personnel qualification

A024 Process Certification

A025 certification of conformance

A040 notification of quality escape

A041 quality management

A042 dart notification by supplier

A043 retention of quality documents

Line Total: \$0.00

PO Total: \$0.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 9

Change Date: 4/3/2018

CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 35626

Certificate Revision : NC

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Drawing number</u>	<u>Description</u>	<u>FDC Serial</u>	<u>Lot</u>
1	1	D2445P	D2445 Rev D	Aft Door Assembly 152133	DAE007-024	2017-11-23
2	1	D2445P	D2445 Rev D	Aft Door Assembly 152134	DAE007-025	2017-12-04
3	1	D2445P	D2445 Rev D	Aft Door Assembly 152136	DAE007-026	2017-12-05
4	1	D2445P	D2445 Rev D	Aft Door Assembly 152138	DAE007-029	2017-12-07
5	1	D2445P	D2445 Rev D	Aft Door Assembly 153342	DAE007-030	2017-12-11

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: Marjorie Geoffrion
Marjorie Geoffrion, Quality Inspector

Date: 2018-01-15



Gamme de Fabrication

# LOT	2017-11-24 (24/11/17)
# SÉRIE(ID)	DAE007-029

Nom de Gamme :	AFT Baggage Door
# de Gamme (et rev.) :	DAE007 Rev.C
Nom pièce – Client :	AFT Baggage Door
# de Dessins (et rev.) :	D2445 Rev.D

2017-11-24 (24/11/17)

Fiche suiveuse

ÉTAPES	DÉPARTEMENTS	DESCRIPTION GÉNÉRALE	DATE RÉVISÉ
[10-80]	PRÉPARATION	Découpe des tissus et préparation de la résine	05 DEC 2017
[80-110]	FINITION/PEINTURE	Application du gelcoat	#26 07 DEC 2017
[120-190]	MOULAGE	Infusion	07 DEC 2017
[200-230]	MOULAGE	Laminage étiquette →	2017-11-24 (24/11/17)
[240-260]	USINAGE	Découpage	#22 13 DEC 2017
[270-310]	FINITION/PEINTURE	Primer/Peinture	#26 03 JAN 2018
[320-330]	EXPÉDITION	Emballage	#28 15 JAN 2018

Gamme préparée par :	Miguel M.-Bergeron
Gamme vérifiée par :	Stéphane Pageau
Gamme approuvée par :	Sylvain Santerre
Date d'émission :	2015-11-30

Gamme révisé préparée par :	Gabriel Bienvenue
Gamme révisé vérifiée par :	Justin Bossé
Gamme révisé approuvée par :	Michel Morin
Date de révision :	2017-11-21

Informations à remplir :
Cases gris pâle

Approbation Qualité	
Avant de produire le CofC, toutes les étapes et les informations requises des gammes subséquentes reliées à ce produit ont été complétées et remplies	
Inspecteur	Qualité

Matériel, outillage et équipement auxiliaire

Matériau / Équipement	Quantité	Date d'expiration	Code FDC	Description
Gelcoat	2017-10-05	2018-06-04	GEL944	White Gelcoat #GEL 944W005
Norox	51749	2018-03-01	RES009	MEKP-9
Résine	2017-10-05	2018-06-04	RES411	DERAKANE 411-350 Momentum
Trigonox	17011A1912	2018-07-03	RES239	Trigonox239
Noyau de mousse	1702905	N/A	NOY205	Gurit Corecell A500 3/8po
7781 (Tissu)	4252384	N/A	FIB781	7781 fini 550 8.7oz/sq yd
Unidirectionnel (Tissu)	5517	N/A	FIB013	TG-13-U-50 9oz/sq yd
Voile (Tissu)	428945	N/A	FIB120	Veil style 120, weave 4HS .3 oz/sq yd
Primer bâtisseur	#22	N/A	GEL060	Feather Fill 100713

Équipement	Matériau	Équipement
Moule DT8036 : MOU310	Sac étanche	Sarrau Tyvek
Gabarit de découpe et perçage GAB365	Ruban Scellant	Lunettes de sécurité
Système pour mise sous-vide	Tissu d'arrachage (56115)	Soulier de protection
	Tubes Spirales 1/4 & 3/8 OD	
	Tubes PE 1/4 & 3/8 OD	
	Connexion de tubes PE 1/2 OD	
	Green Flow (Médium vert)	
	55NC (Agent démoulant)	
	Big Blue Bag	

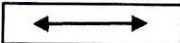
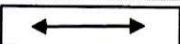
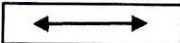
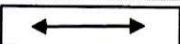
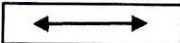
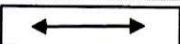
Annexe 1 - AFT Baggage Door - Préparation
Annexe 2 - AFT Baggage Door - Infusion
RES-DAE007

MPS-300-93-31-007	Agent démoulant 55NC
MPS-300-93-31-013	Scellant FMS
MPS-300-93-31-017	Infusion
MPS-300-93-31-020	Finition des rebords
MPS-300-93-31-058	Inspection
MPS-300-93-31-084	Protection/Entreposage

Suivi des révisions

# de révision	Description des modifications de la révision	Date de révision	Révisé par
A	Ajout des annexes 1 et 2, suppression d'inspections.	2016-02-18	Miguel M.-Bergeron
B	Correction du matériel à utiliser et de certaines étapes de Travail lors du laminage.	2017-08-14	Michelle Béliveau
C	Revision drappage, retrait operation wetlayup, revision general	2017-11-20	Gabriel Bienvenue

PRÉPARATION

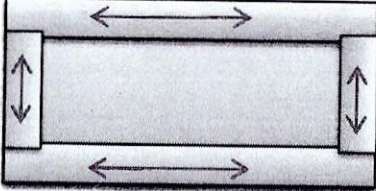
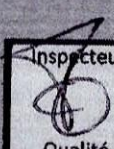
#	Description des étapes de la préparation	Annexe	Date de révision	Révisé par																				
10	<u>Remplir les informations requises sur la première page (cases grises pâles)</u> Demander au coordonnateur de production ou à l'agent de méthode un numéro d'identification (ID)		#12 05 DEC 2017	Sm																				
20	<u>Découper les tissus selon le tableau suivant</u> <table><tr><th>Qté</th><th>Matériau</th><th>Orientation</th><th>Dimensions</th></tr><tr><td>4</td><td>7781</td><td>0°/90°</td><td>24.00" x 31.00"</td></tr><tr><td>2</td><td>Unidirectionnel</td><td></td><td>6.00 " x 23.00"</td></tr><tr><td>2</td><td>Unidirectionnel</td><td></td><td>6.00" x 29.00"</td></tr><tr><td>1</td><td>Voile 3oz</td><td>0°/90°</td><td>6.50" x 8.00"</td></tr></table> Inscrire les numéros de lots des matériaux découpés sur la deuxième page	Qté	Matériau	Orientation	Dimensions	4	7781	0°/90°	24.00" x 31.00"	2	Unidirectionnel		6.00 " x 23.00"	2	Unidirectionnel		6.00" x 29.00"	1	Voile 3oz	0°/90°	6.50" x 8.00"	Annexe 1	#12 05 DEC 2017	
Qté	Matériau	Orientation	Dimensions																					
4	7781	0°/90°	24.00" x 31.00"																					
2	Unidirectionnel		6.00 " x 23.00"																					
2	Unidirectionnel		6.00" x 29.00"																					
1	Voile 3oz	0°/90°	6.50" x 8.00"																					
30	<u>Découper le matériel d'infusion selon le tableau suivant</u> <table><tr><th>Matériau</th><th>Dimension</th></tr><tr><td>Tissu d'arrachage (Peel ply)</td><td>24.00" x 31.00"</td></tr><tr><td>Medium vert</td><td>17.00" x 20.00"</td></tr><tr><td>Big blue bag</td><td>6.50" x 50.00"</td></tr></table>	Matériau	Dimension	Tissu d'arrachage (Peel ply)	24.00" x 31.00"	Medium vert	17.00" x 20.00"	Big blue bag	6.50" x 50.00"	Annexe 1	#12 05 DEC 2017													
Matériau	Dimension																							
Tissu d'arrachage (Peel ply)	24.00" x 31.00"																							
Medium vert	17.00" x 20.00"																							
Big blue bag	6.50" x 50.00"																							
40	<u>Découper le noyau de mousse sur la shop bot</u> - Localisation du programme sur le reseau : Z:\INGENIERIE\PROJETS INTERNES ACTIFS\PRJ014-015 SHOPBOT\Usinage\DART\AFT door - Inscrire le numéro de lot du matériel découpé sur la deuxième page	Annexe 1	CH 2017-12-05																					
50	<u>Thermoformer le noyau de mousse dans le four</u> <u>Four #1 programmes 80°C</u> <u>Mètre le noyau sous vide dans le moule</u> <u>Laisser au four 1h @ 80°C</u> <u>Laisser refroidir à T° ambient avant de debagger</u>	Annexe 1	#29 7 DEC 2017																					

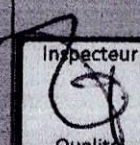
60	<u>Préparer le moule selon MPS-300-93-31-007-NC:</u> - Effectuer des tests de pelage sur la surface du moule - Si nécessaire, appliquer l'agent démoulant 55NC sur le moule et attendre 15 minutes entre les couches - Répéter les opérations jusqu'à l'obtention de résultats positif aux tests de pelage	MPS-300-093-31-007	#17 07 DEC. 2017	Estimé : 0h15 Réel :
70	<u>Masquer le contour du moule</u> Masking tape à Environ 1 po à partir du bord du moule		#17 07 DEC. 2017	

APPLICATION DU GEL COAT

80	<u>Préparer 350g de gelcoat (White Gelcoat #GEL 944W005)</u> Catalyseur : 6.3ml de Norox		#12 07 DEC. 2017	
90	<u>Appliquer le Gel Coat (18-22mils)</u> Heure d'application : <u>10:30</u>		#26 07 DEC. 2017	
110	<u>Point d'inspection (Inspecteur Qualité) :</u> ☒ Épaisseur du gel coat : 18 - 22 mils ☒ Qualité de l'application du gel coat: Uniforme et esthétique		Inspecteur <i>[Signature]</i> Qualité 2017-12-07	

INFUSION

#	Description	Matériau	Date et heure	Signature																												
120	Faire le lay-up de la pièce selon l'annexe 2 et le tableau suivant - Découper les plis au contour de la pièce si nécessaire - Placer le noyau au centre du moule à l'aide du gabarit - Overlaps d'unidirectionnel .5po MAX - Positionner l'unidirectionnel selon la figure suivante → - L'unidirectionnel doit être 1po par-dessus le noyau en suivant la forme  <table border="1"> <thead> <tr> <th>Séquence & description</th> <th>Matériau</th> <th>Drage</th> <th>Inspection</th> </tr> </thead> <tbody> <tr> <td>010</td> <td>7781 (9 oz, Satin)</td> <td>CB</td> <td></td> </tr> <tr> <td>020</td> <td>7781 (9 oz, Satin)</td> <td>CB</td> <td></td> </tr> <tr> <td>040</td> <td>Noyau A500</td> <td>CB</td> <td></td> </tr> <tr> <td>050</td> <td>7781 (9 oz, Satin)</td> <td>CB</td> <td></td> </tr> <tr> <td>060</td> <td>Unidirectionnel TG-13-U-50 (renforts)</td> <td>CB</td> <td></td> </tr> <tr> <td>070</td> <td>7781 (9 oz, Satin)</td> <td>CB</td> <td></td> </tr> </tbody> </table>	Séquence & description	Matériau	Drage	Inspection	010	7781 (9 oz, Satin)	CB		020	7781 (9 oz, Satin)	CB		040	Noyau A500	CB		050	7781 (9 oz, Satin)	CB		060	Unidirectionnel TG-13-U-50 (renforts)	CB		070	7781 (9 oz, Satin)	CB			#17 07 DEC. 2017	
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130	Faire le montage du matériel d'infusion selon l'annexe 2 - Placer le tissu d'arrache - Placer le médium vert - Placer le bag	MPS-300-93-31-017	#17 07 DEC. 2017																													
140	Mettre le montage sous vide : - Vide minimal : 20inHg - Différentiel maximal accepté : 1inHg/5minutes - Faire vérifier le vide par un collègue Vide réel : 29.5 in Hg Différentiel réel : 1 in Hg	MPS-300-93-31-017	#17 07 DEC. 2017																													
150	<u>Inspection du montage sous vide</u> Toutes les composantes suivantes sont bien positionnées selon l'annexe 2 : - Runner ☒ - Tuyaux de vide ☒ - Tissus d'arrache sur toute la surface de la pièce ☒ - Médiums d'infusion ☒ Les tissus ne sont pas froncer (sans "wrinkle") ☒		Inspecteur  Qualité 2017-12-07																													

160	<u>Préparer la résine pour l'infusion selon MPS 300-93-31-017</u> - Formuler la résine selon le document RES-DAE007 - Préparer 800g de résine DERAKANE 411-350 Momentum - Catalyseur : 16g (2%) de Trigonox239 <table><tr><td>Résine 411-350</td><td>800 GR</td></tr><tr><td>Catalyseur Trigonox</td><td>16 GR</td></tr></table> Bien mélanger pendant 2 minutes chronométrées la résine et le catalyseur	Résine 411-350	800 GR	Catalyseur Trigonox	16 GR	RES-DAE007	#12 07 DEC 2017	
Résine 411-350	800 GR							
Catalyseur Trigonox	16 GR							
170	<u>Infuser la pièce selon MPS-300-93-31-017.</u> - Laisser durcir 4h - Heure du début de l'infusion : 15:00	<u>MPS-300-93-31-017</u>	#17 07 DEC 2017					
180	<u>Démouler et identifier la pièce</u> - Identification : Nom-dessin- # de lot (date de début) -ID Ex : D2445 – DAE007-XXX - Identifier sur un masking tape - Faire suivre la procédure avec la pièce - Insérer le document dans une pochette plastifiée et venir coller sur la pièce avec ruban à masquer Heure du démoulage : 8:25	MPS-300-93-31-026, classe II Type A	#17 07 DEC 2017					
190	<u>Point d'inspection :</u> - S'assurer que la pièce est durcie de façon uniforme. ☒ - S'assurer que la pièce est infusée partout et qu'il n'y ait pas de défaut apparent. ☒ - Vérifier la conformité de la pièce selon le dessin et selon le MPS-300-93-31-058 ☒ - Vérifier que l'identification correspond à la commande du client sur le PO ☒		Inspecteur  Qualité 2017-12-08					

Laminage

#	Description	Matériau	Quantité	Remarque
200	<u>Préparer la surface intérieure de la pièce pour le laminage de l'étiquette</u> - Sabler légèrement la surface - Nettoyer à l'aide d'un linge imbibé d'acétone		2017/12/08	Pot

210	<u>Préparer la résine pour le laminage de l'étiquette selon MPS-300-93-31-017</u> • Préparer 50g de résine DERA KANE 411-350 Momentum • Catalyseur : 1g (2%) de Trigonox239 <table border="1"><tr><td>Résine 411-350</td><td>50 GR</td></tr><tr><td>Catalyseur Trigonox</td><td>1 GR</td></tr></table> Bien mélanger pendant 2 minutes chronométrées la résine et le catalyseur	Résine 411-350	50 GR	Catalyseur Trigonox	1 GR		#12 20 DEC 2017
Résine 411-350	50 GR						
Catalyseur Trigonox	1 GR						
220	<u>Positionner l'étiquette sur la porte puis laminer un voile</u> • Le voile doit dépasser d'environ 1po tout autour de l'étiquette • <u>Laisser durcir 4h</u> • Heure du laminage : 9h45		2012-17				
230	<u>Point d'inspection :</u> • Vérifier que l'identification correspond à la commande du client sur le PO ☒		Inspecteur  Qualité 2017-12-10				

USINAGE

240	<u>Percer et découper la pièce</u> • Utiliser le gabarit de découpe et perçage • S'Assurer que la courbure du moule et celle du gabarit se conforment bien • Percer les 8 trous pour les pentures (foret #18) • Fixer le gabarit en place à l'aide des trous de penture • Percer les 8 trous de coin pour les poignées «flush mount» (foret #20) • Tracer la position des trous de poignées puis découper le contour à l'aide de la toupie	Gabarit de découpe/perçage GAB365	#22 13 DEC 2017	
250	<u>Découper les ouvertures pour les poignées «flush mount»</u>	Die grinder	#22 18 DEC 2017	
260	<u>Point d'inspection (inspecteur qualité) :</u> • Aucun défaut majeur ☒ • Position des trous de penture ☒ • Position des trous de poignées «flush mount» ☒		Inspecteur Qualité 2017-12-19	

FINITION

#	Description	Matériau	Date et heure	Temps
270	<u>Sabler la pièce au papier sablé 240</u>		#22 13 DEC 2017	
280	Point d'inspection : • Vérifier le sablage uniforme de la pièce ☒		Inspecteur  Qualité 20-12-2017	
290	<u>Préparer pour la peinture</u> • Nettoyer la pièce au Final Klean V-39215 • Masquer l'identification au masking tape		#26 03 JAN 2018	
300	<u>Appliquer le primer bâtisseur Feather Fill</u>		#26 03 JAN 2018	
310	Point d'inspection : • Vérifier la peinture de la pièce ☒		Inspecteur  Qualité	

ENTREPOSAGE

#	Description	Matériau	Date et heure	Temps
320	Emballer et entreposer la pièce.		#28 15 JAN 2018	Estimé : 0h05
330	<u>Livraison :</u> Date et heure de livraison prévu : _____ Date et heure de livraison actuel : _____		#28 15 JAN 2018	Estimé : 0h05



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

MAR 26 2018

001939

D350-588-041
Job Sheet 174872



Part No: D350-588-041

Job Qty: 1 ea

Part Name: Aft Door Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/18

Job Tracking No:

Due Date: 4/3/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG DSI9690 REV A , DSI9760-011 REV A , D2445/D350-588 REV D/D IPP P 04.02.04 Reformat KJ/DS IPP
Rev:Q as per DSI9414 DD verified by:EC IPP Rev:R add pick kit DD 10.03.29 verified by:EC IPP REV:S
14.04.28 AS PER DSI9690 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	1 pcs		4/2/18	0.00	0.00	Purchasing		
140	Small Fab	1 pcs		4/3/18	0.00	1.96	Small Fab-4		MAR 26 2018
150	QC	1 pcs		4/3/18	0.00	0.00	QC5		
155	Packaging	1 pcs		4/3/18	0.00	0.00	Packaging1-3		
160	QC	1 pcs		4/3/18	0.00	0.00	QC4		
165	DC	1 pcs		4/3/18	0.00	0.00	DC		
170	Packaging	1 pcs		4/3/18	0.00	0.00	Packaging3-1		
180	QC21-FG	1 Ea		4/3/18	0.00	0.00	QC21		

disassembled
No label on
door
see newwlb
175324



Container No: S054423



Part: D350-588-041

Job No: 174872

Serial No/Batch: S054423

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/23/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2445	Aft Door 350	1 Ea (1 ea)	110-Purchasing	F114689
AN526C832R9	Screw	8 Ea (8 ea)	140-Small Fab	5006315
D2143	Hinge Bracket	1 Ea (1 ea)	140-Small Fab	F152427
D2144	Hinge Doubler	1 Ea (1 ea)	140-Small Fab	F150971
D2463	1/2" Seal (\$ Per Foot)	7.2500 ft (7.25 ea)	140-Small Fab	5021111
D2585	Latch Clamp	2 Ea (2 ea)	140-Small Fab	5038640
D2586	Door Latch	2 Ea (2 ea)	140-Small Fab	5031323
D2621	Latch Plate	2 Ea (2 ea)	140-Small Fab	5049919
D2857-1	Hinge Bracket	1 Ea (1 ea)	140-Small Fab	5018550
D2857-2	Hinge Bracket	1 Ea (1 ea)	140-Small Fab	5016879
MS21042L08	Nut	8 Ea (8 ea)	140-Small Fab	5038764
MS21042L3	Nut	2 Ea (2 ea)	140-Small Fab	5003923
MS27039-1-15	Screw	2 Ea (2 ea)	140-Small Fab	5015269
NAS1149D0363J	Washer	2 Ea (2 ea)	140-Small Fab	FM137587
NAS1149DN832J	Washer	8 Ea (8 ea)	140-Small Fab	FM128403-4
AN526C1032R7	Screw	2 Ea (2 ea)	155-Packaging	5015689
AN526C832R8	Screw	8 Ea (8 ea)	155-Packaging	F121844
D2150	Packer Doubler, Hinge	2 Ea (2 ea)	155-Packaging	F152281
D2151	Packer Doubler	2 Ea (2 ea)	155-Packaging	5047790
D2153	Door Prop	1 Ea (1 ea)	155-Packaging	F145373
D2154	Bracket, Stud	1 Ea (1 ea)	155-Packaging	5011812
D2237	Striker Plate	2 Ea (2 ea)	155-Packaging	F144533
D2461	Neoprene D Seal (\$Per Foot)	7.2500 ft (7.25 ea)	155-Packaging	F132942
D2589	Keys, Key Chain	1 Ea (1 ea)	155-Packaging	F156171
D2690-17	Cable	1 Ea (1 ea)	155-Packaging	F162847
D2858-1	Hinge Bracket	1 Ea (1 ea)	155-Packaging	F152277
D2858-2	Hinge Bracket	1 Ea (1 ea)	155-Packaging	F160686
D5080-041	Striker Plate Assembly	2 Ea (2 ea)	155-Packaging	5006060
FG-778150-550-ROL	7781 9 oz Glass 50" x 125 yd	1 sf (1 ea)	155-Packaging	FM134294
MS20426AD3-4	Rivet	12 Ea (12 ea)	155-Packaging	5018536
MS20470AD4-5	Rivet, Universal Head	18 Ea (18 ea)	155-Packaging	5016879
MS21042L08	Nut	10 Ea (10 ea)	155-Packaging	5038764
MS21042L3	Nut	4 Ea (4 ea)	155-Packaging	FM138336-10
MS27039-08-11	Screw	2 Ea (2 ea)	155-Packaging	5015269
NAS1149D0363J	Washer	2 Ea (2 ea)	155-Packaging	FM137587-15
NAS1149DN832J	Washer	16 Ea (16 ea)	155-Packaging	

check
Kit.
D2144 ???
MS21042L08 ?

Pack 1-3
A
Loadable

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																																																																									

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2445	1	1	0
140-Small Fab	AN526C832R9	8	237	0
	D2143	1	18	0
	D2144	1	19	0
	D2463-087 (X1)	7 (lost)	449	0
	D2585	2	34	0
	D2586	2	22	0
	D2621	2	21	0
	D2857-1	1	6	0
	D2857-2	1	1	0
	MS21042L08	8	2,591	0
	MS21042L3	2	2,670	0
	MS27039-1-15	2	400	0
	NAS1149D0363J	2	3,095	0
	NAS1149DN832J	8	2,406	0
155-Packaging	AN526C1032R7	2	64	0
	AN526C832R8	8	156	0
	D2150	2	31	0
	D2151	2	26	0
	D2153	1	8	0
	D2154	1	20	0
	D2237	2	46	0
	D2461	7	600	0
	D2589	1	245	0
	D2690-17	1	24	0
	D2858-1	1	21	0
	D2858-2	1	9	0
	D5080-041	2	14	0
	FG-778150-550-ROL	1	420	0
	MS20426AD3-4	12	3,924	0
	MS20470AD4-5	18	3,686	0
	MS21042L08	10	2,591	0
	MS21042L3	4	2,670	0
	MS27039-08-11	2	1,493	0
	NAS1149D0363J	2	3,095	0
	NAS1149DN832J	16	2,406	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐						

REFERENCE ONLY

3.0 PARTS LIST:

The part lists of D350-588 Rev. D and ICA-D350-588 Rev. 0 are amended as follows.

IS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D5080-041	STRIKER PLATE ASSY (AS355 N/NP MODELS ONLY)
2	2	D2237	STRIKER PLATE

WAS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D2237	STRIKER PLATE

Customers who need to upgrade a D350-588-011/-041 kit that has been previously purchased from Dart can procure the DSI 9690-011 Kit from Dart.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9690-011	STRIKER PLATE MODIFICATION KIT
2	D5080-041	STRIKER PLATE ASSEMBLY

4.0 WEIGHT AND BALANCE:

This DSI has a negligible effect on Weight and Balance of the aircraft.

5.0 MAINTENANCE:

Maintain the D5080-041 Striker Plates in accordance with the procedures for the D2237 Striker Plates as outlined in ICA-D350-588.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH92-41
ISSUE NO.: 8

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9690	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STRIKER PLATE MOD	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.3 **WEIGHT AND BALANCE**

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 **PARTS LISTS**

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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Revision: D

Date: 02.01.17

Change Record

PAGE 1 OF 1

Part Number: D350-588-041Description: AFT DOOR ASSEMBLY[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
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